

thereof, and a piston skirt 24 formed as one piece with the pin bosses of the same forged material. The skirt includes a pair of skirt portions 26 which are arranged on laterally opposite sides of the piston in spaced relation to the pin bosses 20, and intervening strut portions 20 extending between and interconnecting the skirt portions 26 and pin bosses 20.

Rewrite the paragraph beginning at line 12 of page 13 as follows:

In addition to the upper slots 128, the skirt portions 326 may further be formed with one or more additional slots 132 intermediate the upper and lower ends of the skirt portions 310. One such slot 132 is illustrated in Figure 10 as being in line with the pin bore axis B. The slots 128,132 serve to lighten the piston 10 by eliminating material and further assist in decreasing oil consumption of an engine by presenting free edges 130,134 which scrape oil from the walls of a piston cylinder during operation of the piston. The slots 128,132 further serve to vent the piston skirt portions 126 and to uncouple them from the head of the piston in order to isolate the skirt portions 126 from the direct flow of heat from the head and to introduce cooling spaces into the skirt portions 126.

Rewrite claim 7 as follows:

Q3 Sub B'
7(Amended). The method of claim 1 wherein the recesses forged in the strut portions are formed to extend above and below the pin bore axis.

Rewrite claim 60 as follows:

Sub B'7
60(Amended). The piston of claim 59 wherein said joint comprises a friction weld joint.

(Rewrite claim 61 as follows.)

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61(Amended). The piston of claim 59 wherein said inner surface of said inner walls extend vertically upwardly or at a positive outward draft angle from said inner faces to said joint.

(Rewrite claim 62 as follows.)

62(Amended). The piston of claim 59 wherein said cavity extends into said upper crown

above said joint in said undercut relation to said inner faces of said pin bosses.

Rewrite claim 71 as follows:

71(Amended). A monobloc piston comprising:

an upper crown portion fabricated of steel having a head portion formed with at least one circumferentially extending mating surfaces; and
a lower crown portion forged from a single piece of steel including an upper head portion having at least one circumferentially extending mating surface, a pair of pin boss portions extending downwardly from said upper head portion in laterally spaced relation to one another; and an integral skirt formed as a single forged piece with said pin boss portions including a pair of opposed skirt portions spaced from said pin boss portions and strut portions extending between and intermediate said skirt portions and said pin boss portions, said lower crown portion being multi-axially forged to include forged recesses in the piston skirt in one or more areas inaccessible by forging in the longitudinal direction of the piston; said mating surface of said lower crown portion being welded to said mating surface of said upper crown portion.

Cancel claim 76.

Rewrite claim 77 as follows:

77(Amended). A method of making a piston comprising:

fabricating an upper crown portion of steel having a head portion with at least one circumferentially continuous joining surface; and
multi-axially forging a lower crown portion from a single piece of steel including an upper head portion having at least one corresponding circumferentially continuous joining surface, a pair of pin boss portions extending downwardly from the upper head portion, and a piston skirt forged as one piece with the pin boss portions, and including a

forged traverse recess in the lower crown portion inaccessible by forging in a longitudinal direction of the lower crown portion and connecting the joining surfaces of the upper and lower crown portions to unite the upper and lower crown portions.